

Work Order ID 128474-2 *SPLIT****128474***

Page 1

Item ID: D2274

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Radius Block

Stop

NS2

Start Date: 1/07/15

Start Qty: 270.00

270

Cust Item ID:

Required Date: 1/16/15

Req'd Qty: 270.00

270

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 15-01-20

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2274

Rev F

100

0.00

100

SHEAR

Shear

Memo

0.00

Shear

blanks 9.00" long +/- 0.030"

Note: 1 blank makes 9 pieces

P 15-02-0531 blanks

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio D2274

P 15-02-05282

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

P 15-02-05282

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[illegible]

Work Order ID 128474

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128474

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Item ID: D2274 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 1/07/15 Start Qty: 270.00 ***270*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 270.00 ***270*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							38 9-89
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>STOCK</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

253

FEB 20 2015

253

SP 15-02-20

MLJ 15-02-23

MF

15-2-20

Picklist Print

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Work Order ID: 128474

128474

Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 1/07/15

Required Date: 1/16/15

Start Qty: 270.00

Required Qty: 270.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	47.6000	0.0916	27			

M6061T6B00750X00 125

6061-T6 Bar .750 x .125

Location

Loc Qty

Loc Code

MAT001

47.6

M127818

20.3

M129167

27.3

M131 392

15-02-05

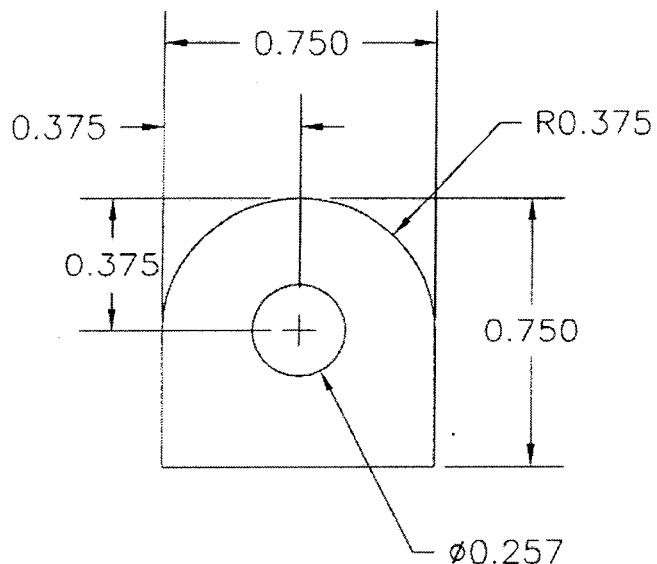
3.75'

20'



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/19 KE



00.05.16
00.05.16

0.063 x 45° CHAMFER
R0.0 - 0.13

1501-20
MS
184881

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED